

Date: Tuesday, 1/3/2006 9:33:21 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP WELDMENT
Job Number :	25341		
Estimate Number :	10698		
P.O. Number :	N/A	Part Number :	D34631
This Issue :	1/3/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3463 REV A
First Issue :	1/3/2006	Project Number :	N/A
Previous Run :	24928	Drawing Revision :	A
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	1/10/2006
Written By :	<u>See comment below</u>		Qty: 1 Um: Each
Checked & Approved By :	<u>See comment below</u>		
Comment :	EST REV. A 05.11.17 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M316TR100W120	Inventory
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Comment: Qty.: 2.1872 f(s)/Unit Total : 2.1872 f(s)
 AISI 316 SS seamless tubing 1.00" OD X 0.120 wall
 (M316TR1.00w120)
 Batch: M18457

FF 06-01-03

2.0	BAND SAW	BAND SAW
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
 BAND SAW
 Cut blank 25.00 " long

N/A R

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
 SMALL & MEDIUM FAB RESOURCE 1
 1-Bend as per dwg D3463
 2-Trim to lenght per dwg D3463

IB

0609

3- Deburr

FF

06-01-03

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 INSPECT WORK TO CURRENT STEP
 Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

J 06-01-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/1/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 9:33:21 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25341

Part Number: D34631

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3463

MS 06/01/04

2-Deburr as per dwg D3463

MS 06/01/04

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/01/04

7.0

QC8

SECOND CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

SECOND CHECK

MS 06/01/04

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: _____

MS 06/01/05

9.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

MS 06/01/06

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MS 06/01/06

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

